

# Work Order ID 76395

**\*76395\***

Page 1

November-11-11 12:47:26 PM

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 11/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 25/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	Rev H U/R/ DEO <u>Rev I 11.11.14</u>

100	MORI SEIKI CNC LATHE LARGE	0.00							
<b>*100*</b>									
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	Turn as per Folio FA599 Rev: <u>1</u> & Dwg D3391 Rev: <u>1</u>								
	***scribe batch # on fwd end at 90 degree***								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

111	QC8- Inspect parts - second check	0.00							
<b>*111*</b>									
QC	Memo	0.00							
Quality Control									

1 Ø  
mm 11/11/16  
1 Ø  
mm 11/11/16  
B.A 11/11/19  
1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*76395\***

November-11-11 12:47:26 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 11/11/2011    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 25/11/2011      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 76395

\*76395\*

Page 4

November-11-11 12:47:26 PM

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Tube Assembly

Start Date: 11/11/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

\*180\*

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig.

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

3 11/11/23

3 11/11/24

DP/ET 11-12-1

DP/ET 11-12-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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November-11-11 12:47:26 PM

**\*76395\***

Page 5

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>M</u>	<u>11</u>	<u>12-01</u>	<u>(1)</u>
200 <b>*200*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>(1)</u>	<u>0</u>	<u>SAD 11-12-01</u>	
210 <b>*210*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<u>DP</u>	<u>11-12-1</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 6

November-11-11 12:47:26 PM

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
<b>*220*</b>	Skidtubes								<i>DH</i>
Skidtubes	Memo	0.00							<i>11/12/02</i>
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>112070</u> exp. date: <u>02/12</u> cure time 12hrs as per QSI0015								
230	QC5- Inspect part completeness to step on W/O	0.00							
<b>*230*</b>									
QC	Memo	0.00							<i>8 ulizlos</i>
Quality Control									
235	Pressure Wash per QSI005 4.3	0.00							
<b>*235*</b>									<i>1 BR 11-12-5</i>
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*76395\***

November-11-11 12:47:26 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\* 1 \***

**\* 1 \***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
-----	--	------

Memo

START TIME: 12:00 0.00

OVEN TEMPERATURE: 320.0

FINISH TIME: 12:00

## Powder Coating

250

QC3- Inspect Part Finish	0.00
--------------------------	------

<b>Memo</b>	0.00
-------------	------

QC

## Quality Control

260

0.00

<b>Memo</b>	0.00
-------------	------

HandFinish

## Hand Finishing

1-Install inserts as per Dwg D3391  
 2-Install Aft Cap as per Dwg D3391  
 - A/R Sikaflex-241/-291 1/1/19443  
 Sikaflex expiry date: 12/6/1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 76395

**\*76395\***

Page 8

November-11-11 12:47:26 PM

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 Required Date: 25/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
<b>*270*</b>									
QC	Memo	0.00							
Quality Control									
280	Identify as per dwg & Stock Location: <u>W10</u>	0.00							
<b>*280*</b>									
Packaging	Memo	0.00							
Packaging									
290	QC21- Final Inspection - Work Order Release	0.00							
<b>*290*</b>									
QC	Memo	0.00							
Quality Control									

*Sulizlor*

*0412-742-043 / B76398*

*1 0 11/12/06*

*11/12/08*

*MF 11-12-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

November-11-11 12:47:30 PM

Page 1

Work Order ID: 76395

**\*76395\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC  
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM  
 IPP rev D 07.03.20 revF dwg EC  
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD  
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090		Manufactured	No			100	Each	17.0000	1	1			

**\*D6014-090\***

ALUMINUM EXTRUSION

\*\*

Location

Loc Qty

Loc Code

LG

17

66179

17

D3670-4-200

Manufactured No

230

Each

104.0000

4

4

**\*D3670-4-200\***

SPACER

\*\*

Location

Loc Qty

Loc Code

LG

12

71850

12

LG001

92

72851

92

amm.l 11/11/14

u/12/02

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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November-11-11 12:47:30 PM

Work Order ID: 76395

**\*76395\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

243.0000

1

1

**\*D2646\***

Aft Cap

\*\*

B73825 (x1) M 11/12/06

Location

Loc Qty

Loc Code

FP002

226

73294

26

73825

200

FP004

5

68280

5

FP006

5

62678

5

FP-4

3

70945

1

71070

2

fp5

4

71038

4

D3537-1

Manufactured No

270

Each

90.0000

1

1

**\*D3537-1\***

Wearpad

\*\*

B76217 (x1) M 11/12/06

Location

Loc Qty

Loc Code

FP002

83

74436

56

74597

27

FP017

7

69817

5

70686

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-7 Manufactured No

270 Each 19.0000 1 1

**\*D3537-7\***

Wearpad

\*\* 1376208 (x1) 11/12/06

D4095-047

OP 11.12.06

Location	Loc Qty	Loc Code
FP	4	
71689	4	
FP001	12	
74617	12	
FP017	3	
71689	3	

D3553-1 Manufactured No

270 Each 35.0000 1 1

**\*D3553-1\***

Gasket

\*\* N/A

N/A OP 11.12.06

Location	Loc Qty	Loc Code
FP013	35	
56568	2	
73155	33	

D3553-3 Manufactured No

270 Each 20.0000 1 1

**\*D3553-3\***

Gasket

\*\* N/A

N/A OP 11.12.06

Location	Loc Qty	Loc Code
FP	20	
31631	20	

W/O:		WORK ORDER CHANGES					
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Page 4

November-11-11 12:47:30 PM

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**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each 688.0000 2 2

**\*D3672-1\***

Phenolic Washer

\*\*

HL 11/12/06

Location

Loc Qty

Loc Code

FP-A

424

52505

0

66821

424

ST074

264

X2

72229

264

ALS4-1032-130 Purchased No

260 Each 2,000.000 14 14

**\*AI S4-1032-130\***

Insert

AW57-1032-130

\*\*

1119530(x14) HL 11/12/06

Location

Loc Qty

Loc Code

ST280

1984

119084

1984

ST281

16

117717

2

118237

12

118312

2

ALS4-1032-225 Purchased No

270 Each 2,181.000 12 12

**\*AI S4-1032-225\***

Insert

\*\*

HL 11/12/06

Location

Loc Qty

Loc Code

ST281

2181

108696

285

110768

62

118386

858

118966

976

Y12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

November-11-11 12:47:30 PM

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\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

270 Each 2,163.000 6 6

\*AN3C4A\*

BOLT

\*\*

ul 11/12/06

## Location

## Loc Qty

## Loc Code

ST350

2163

117313

2

117688

5

117872

22

118112

16

118451

2

118706

142

118838

974

119328

1000

XL

AN3C5A Purchased No

270 Each 987.0000 4 4

\*AN3C5A\*

Bolt

\*\*

ul 11/12/06

## Location

## Loc Qty

## Loc Code

FP-A

7

115835

7

ST350

980

116419

28

117343

17

117764

166

117872

2

118451

267

119127

500

XL

AN960C10L NAS1149C0332 Purchased No

270 Each 0.0000 10 10

\*AN960C10I \*

washer

\*\*

1119736 (x10) ul 11/12/06

November-11-11 12:47:30 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	76395
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b>	D3391-3
<b>Inspection Dwg:</b> D3391 <b>Rev:</b> H		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Lathe Section</b>						
14.000	+/-0.010	14.000	✓		tape	gmm1-02
3.500	+/-0.010	3.502	✓		vern	CNC-08
88.93	+/-0.030	88.920	✓		tape	gmm1-02
Ø3.200	+/-0.010	3.201	✓		vern	CNC-08
88.93	+/-0.030	88.920	✓		tape	gmm1-02
Ø3.750	+/-0.010	3.750	✓		vern	CNC-06
30° x 160° chamfer	+/-0.010	30° x 160	✓		11	

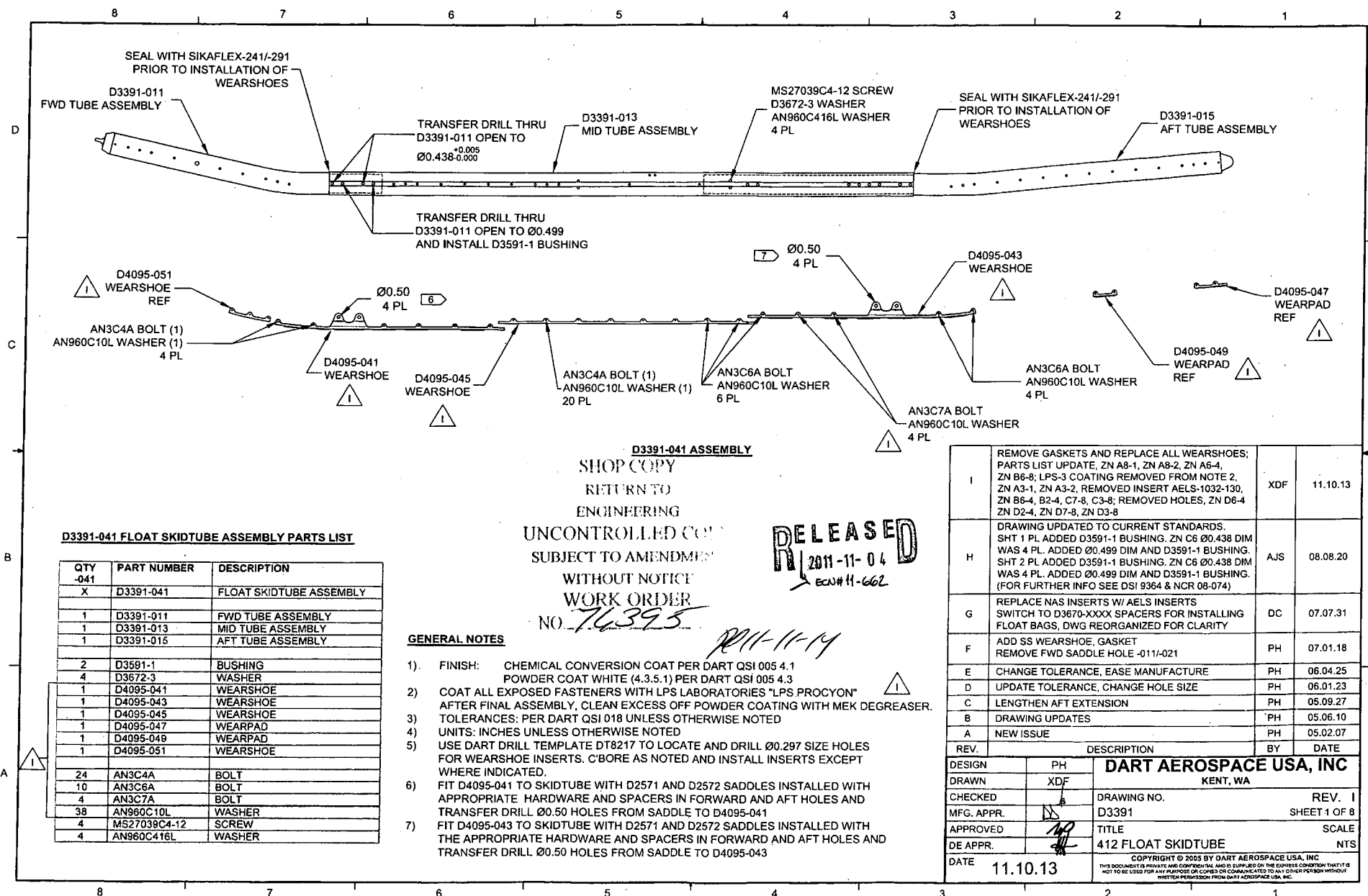
<b>Measured by:</b> <i>MM</i>	<b>Date:</b> 11/11/15
<b>Audited by:</b> <i>RR</i>	<b>Date:</b> 11-11-21

<b>HAAS Section</b>						
1.526	+0.000/-0.030	1.520	✓		VERN	JCM06
7.500	+/-0.010	7.501	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.298	✓			
0.200	+/-0.010	0.198	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	0.690	✓			
R0.062	+/-0.010	0.062	✓			
Ø0.484	+0.005/-0.001	0.485	✓			

<b>Measured by:</b> <i>SC</i>	<b>Date:</b> 11/11/17
<b>Audited by:</b> <i>RR</i>	<b>Date:</b> 11-11-21

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	





**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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WITHOUT NOTICE  
WORK ORDER  
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ECN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -0111-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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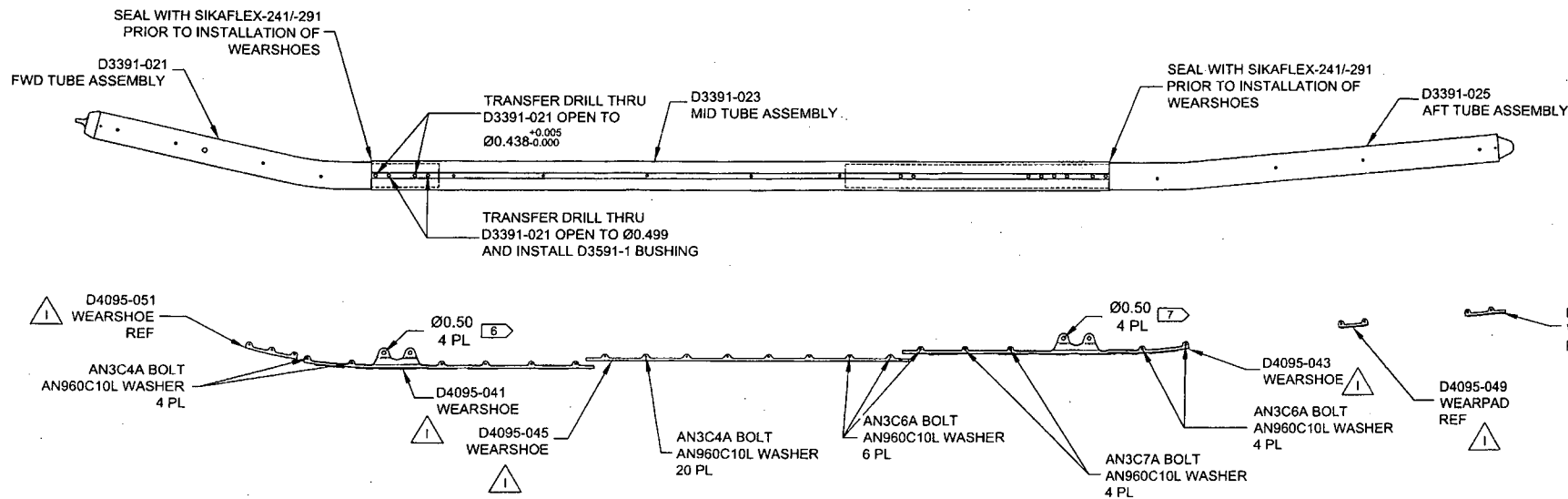
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



#### D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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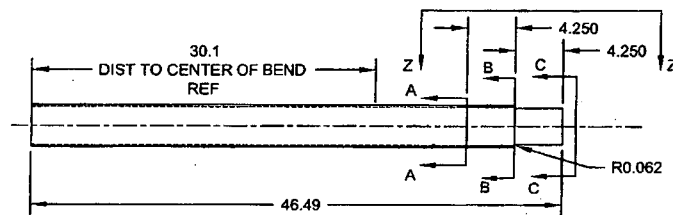
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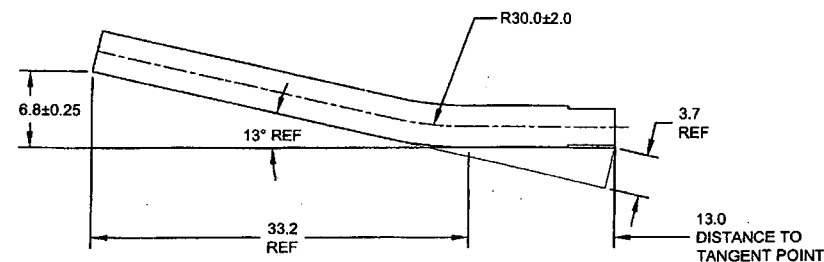
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

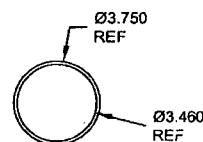




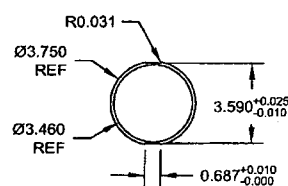
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



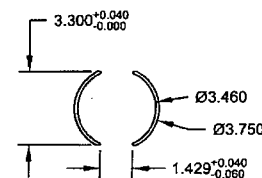
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



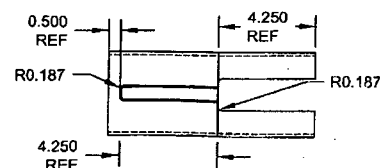
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
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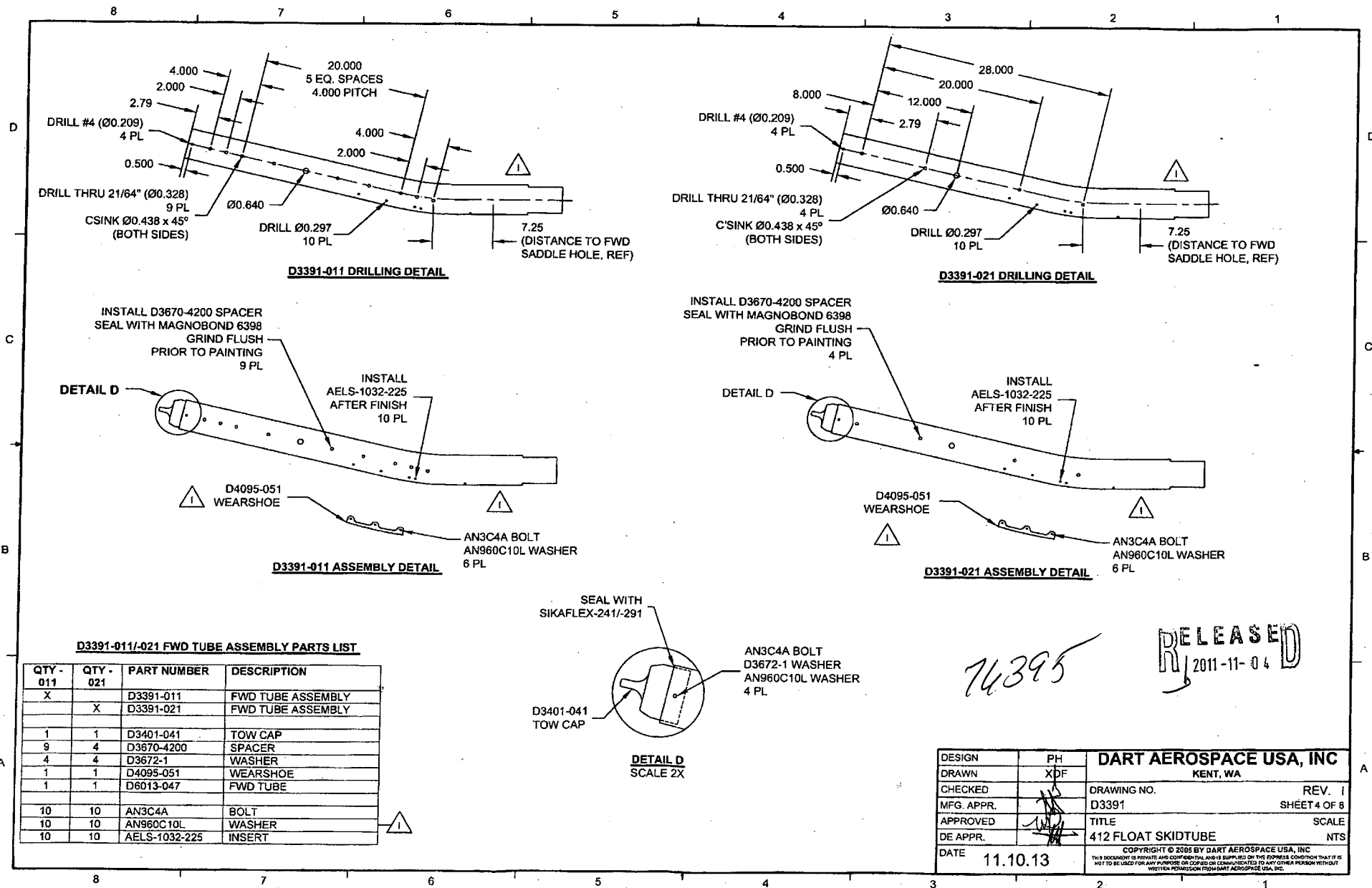
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

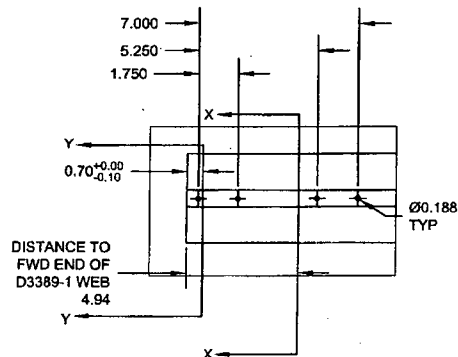
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

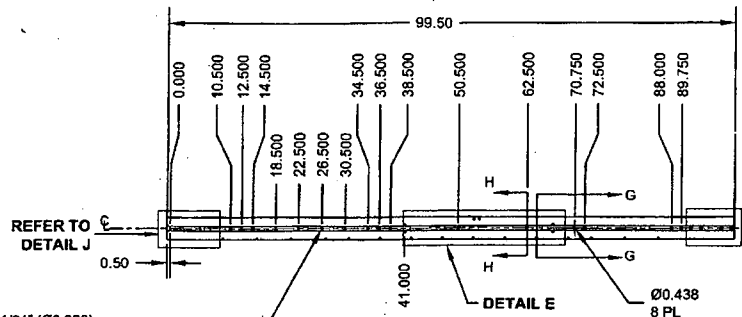
**NOTE:** Date & initial all entries

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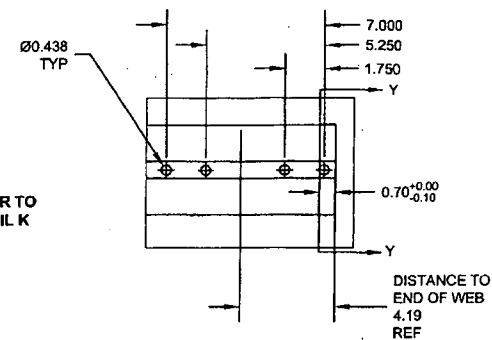
DETAIL J  
SCALE 4X

DRILL THRU 21/64" (Ø0.328)  
CSINK Ø0.438 X 45° (BOTH SIDES)  
12 PL



D3391-013 ASSEMBLY DETAIL

REFER TO  
DETAIL K

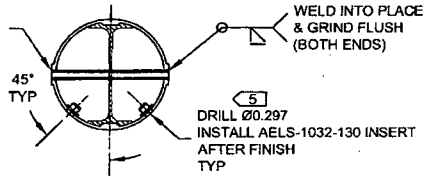


DETAIL K  
SCALE 4X



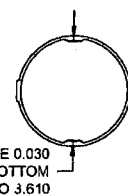
SECTION G-G  
SCALE 5X

INSTALL  
D3681-1 SPACER

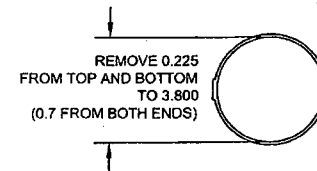


SECTION H-H  
SCALE 5X

REMOVE 0.030  
FROM TOP AND BOTTOM  
TO 3.610

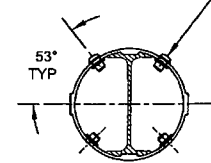


SECTION X-X  
SCALE 5X

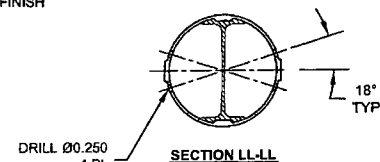


SECTION Y-Y  
SCALE 5X

DRILL Ø0.297  
INSTALL AELS-1032-130 INSERT  
MS27039C1-09 SCREW  
D3672-1 WASHER  
AN960C10L WASHER  
AFTER FINISH  
4 PL



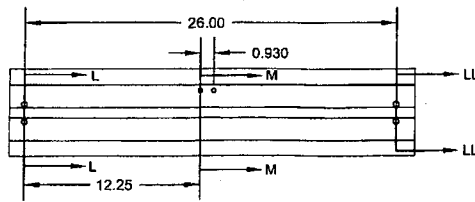
SECTION M-M  
SCALE 5X



SECTION LL-LL  
SCALE 5X

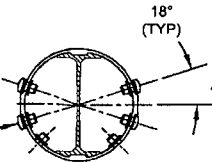
D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E  
SCALE NONE

DRILL Ø0.391  
INSTALL ALS4-428-165 INSERT  
MS27039C4-08 SCREW  
D3672-3 WASHER  
AN960C416L WASHER  
AFTER FINISH  
4 PL



SECTION L-L  
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

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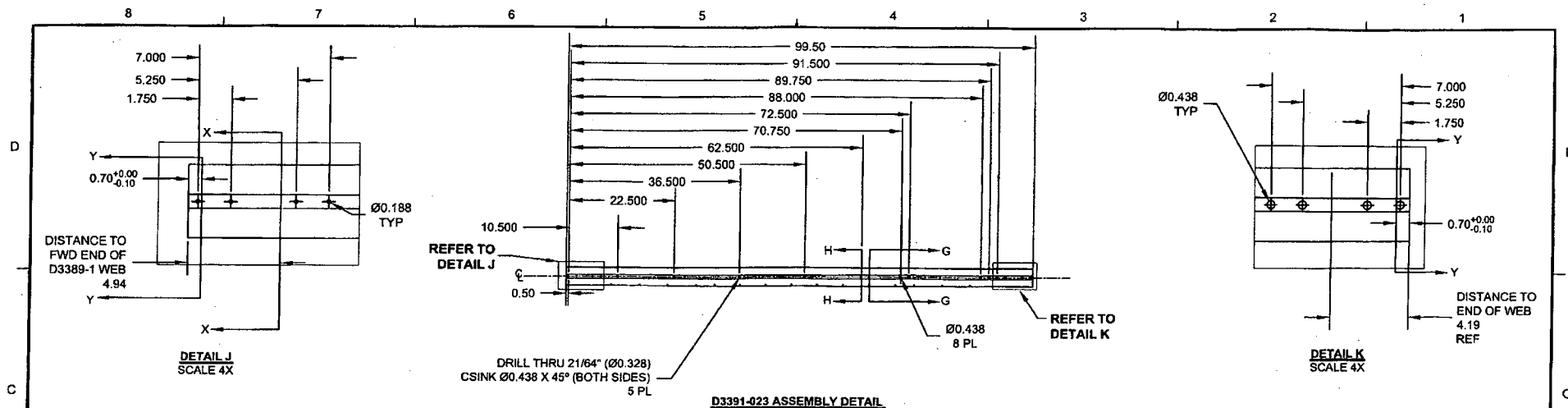
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

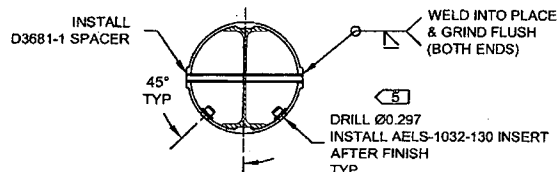
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

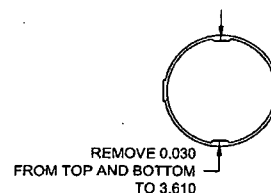
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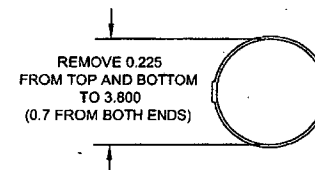
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

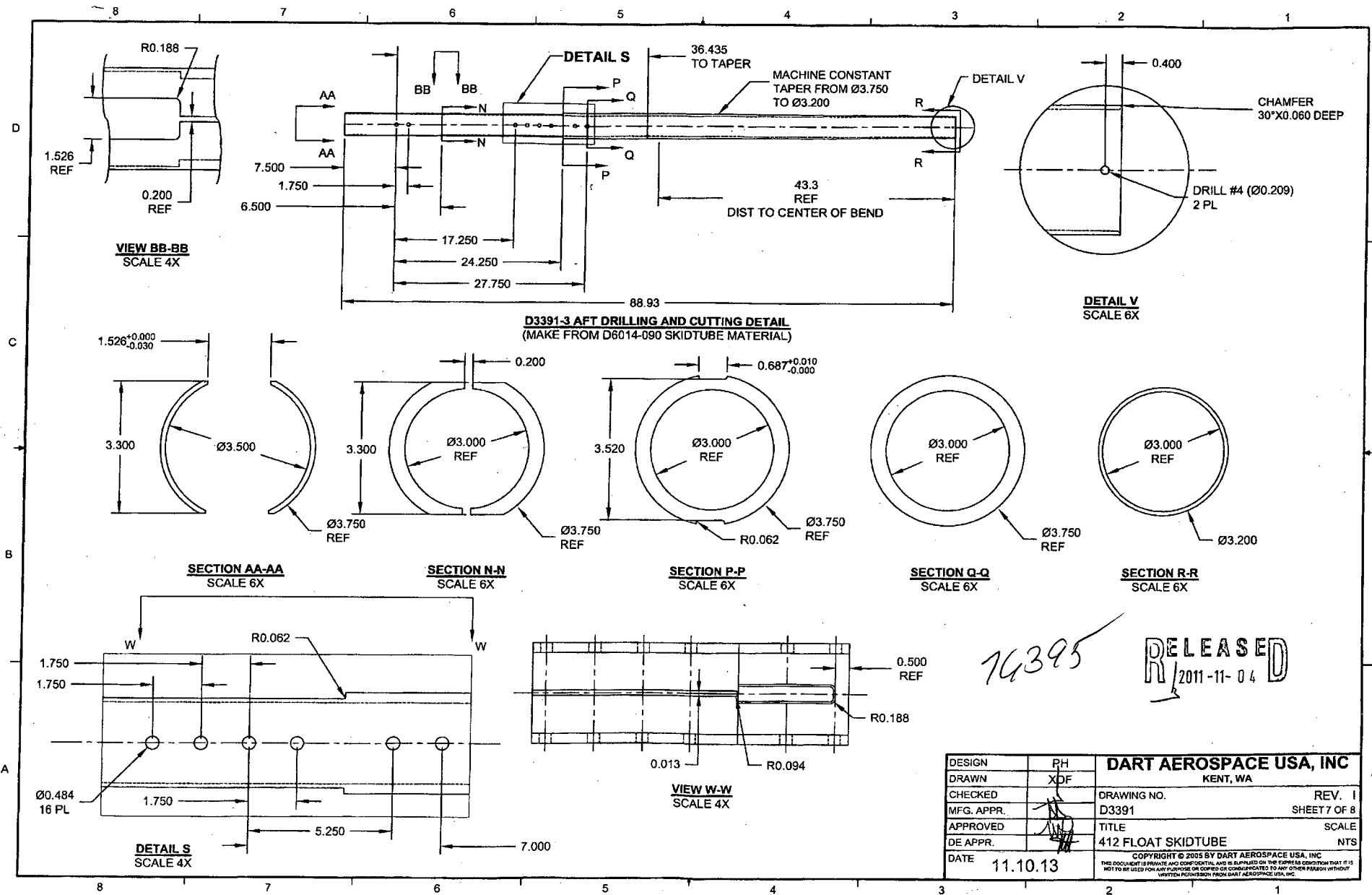
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





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MFG. APPR.		D3391	SHEET 7 OF 8
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DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

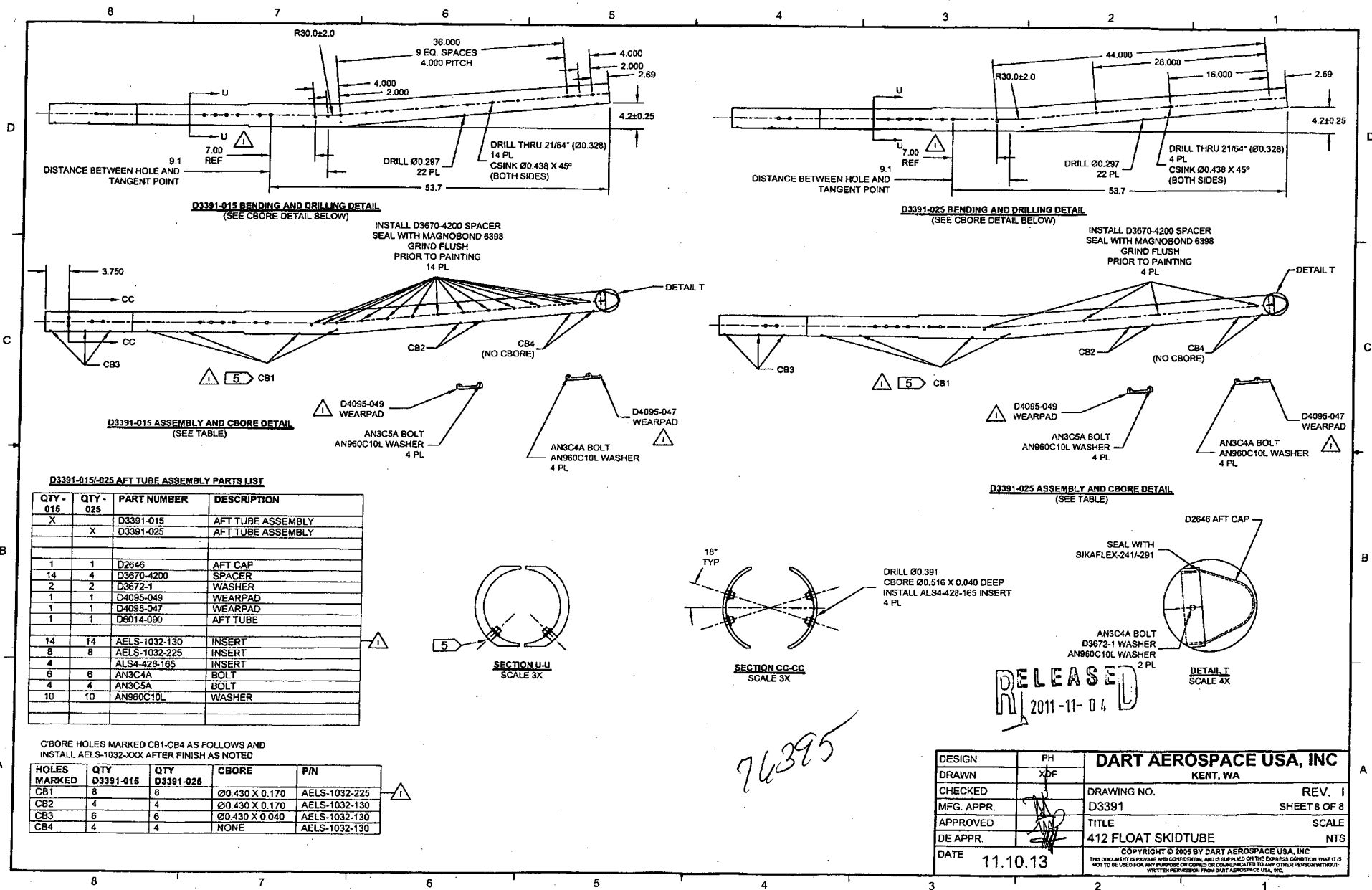
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries